

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027960**Date Inspected:** 13-Jul-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1930**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** jobsite**CWI Name:** Bonifacio Daquinag Jr.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS project**Summary of Items Observed:**

This Quality Assurance (QA) Inspector, Craig Hager was on site at the job site between the times noted above.

This QA Inspector was on site to randomly observe Quality Control (QC) personnel perform Non-Destructive Testing (NDT) and /or monitor American Bridge/Fluor (ABF) welding operations. This Quality Assurance (QA) Inspector, Craig Hager observed the following.

Previously this QA Inspector and QC Inspector Andrew Keech had been working together performing Ultrasonic Testing (UT) at Electro Slag Weld (ESW) W-045 (H), face A, from Y-0 to Y-4000. This QA Inspector had performed UT verification after QC Inspector Andrew Keech and observed several recordable indications not documented on the QC inspection report. Lead QC Inspector Bonifacio Daquinag Jr. informed this QA Inspector he would have QC Inspector Scott Kortum UT these areas later in the shift this date. Note that QC Inspector Andrew Keech has not been on site this week. This QA Inspector informed Lead QA Inspector Bill Levell of the conversation noted above and was requested to assist Structural Material Representative (SMR) Bahjat Dagher and Keivan Hassan reviewing welding documents.

This QA Inspector assisted SMR Keivan Hassan with the review of several Welding Operator qualification records and Procedure Qualification Records (PQR).

This QA Inspector assisted SMR Bahjat Dagher with the review of a Procedure Qualification Records (PQR) for welding HPS70W material.

This QA Inspector was informed by Lead QC Inspector Bonifacio Daquinag Jr. the task assigned to QC Inspector

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Scott Kortum had taken longer than anticipated and that he would not be available to perform the UT as noted above.

Orthotropic Box Girder (OBG) sections Drop In: This QA Inspector had been requested to perform a visual verification by Lead QC Inspector Bonifacio Daquinag Jr. on the following locations weld joints; 13W- PP123- E2.1-BF-1 and BF-2 and 13W- PP123.5- E2.1-BF-1 and BF-2. This QA Inspector performed a visual verification and observed the welds on the outboard side of BF-2 at both locations did not appear to be ready and/or meet the minimum requirements. The other weld joints; BF-1 at both locations appeared to meet the minimum requirements. This QA Inspector informed Lead QC Inspector Bonifacio Daquinag Jr. of the observations noted above and was informed that this QA Inspector had mistakenly been informed the BF-2 welds were ready for QA verification. This QA Inspector also informed Lead QC Inspector Bonifacio Daquinag Jr. the beam at these locations had been marked with multiple weld joint number, but arrows or other information to identify the welds was not present.

This QA Inspector did not observe welding being performed this date.

Summary of Conversations:

This QA Inspector had general conversations with American Bridge/Fluor (ABF) personnel, QC personnel and Caltrans personnel during the shift. Except as described above there were no notable conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Hager,Craig	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
